

Work Order ID 57583

April 9, 2010 10:23:55 AM



Page 1

Item ID: D2221

Accept



Setup Start



Revision ID:

Stop



Item Name: 350 Basket Base

Start Date: 4/09/10 Start Qty: 1.00



Cust Item ID:

Required Date: 4/16/10 Req'd Qty: 1.00

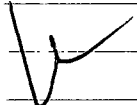


Customer:

Reference:

Run Start



Approvals: Process Plan:  Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D2221	Rev H
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100		0.00
-----	--	------



Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221
2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221
3- tack weld mesh on basket as per dwg D2221
A/R ER316 S.S. Rod Batch: 111679

QC 10.04.19

110	QC9- Inspect visual per QSI004- Fusion Welds	0.00
-----	--	------



QC

Memo

0.00

Quality Control

QC 10.04.19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

QC6- Inspect dimensions to drawing

0.00

8/10/04/13



QC

Memo

0.00

Quality Control



130

Pressure Wash
White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel
11/14/207

0.00

=> 10/04/19



Powdercoat

Memo

0.00

Powder Coating

1- Plug holes prior to

1ST COAT:
START TIME: 1:15 pm
OVEN TEMPERATURE: 400°F
FINISH TIME: 1:45 pm
*****2nd coat if necessary*****

2ND COAT:
START TIME: 1:55 pm
OVEN TEMPERATURE: 400°F
FINISH TIME: 2:05 pm



W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 57583

April 9, 2010 10:23:56 AM



Page 3

Item ID: D2221

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Setup Start



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Stop



Item Name: 350 Basket Base

Start Date: 4/09/10 Start Qty: 1.00



Cust Item ID:

Required Date: 4/16/10 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 QC Quality Control	QC3- Inspert Part Finish Memo	0.00 0.00							
150 Packaging Packaging	Identify as per dwg & Stock Location: <u>G-A</u> w/o 57580 Memo	0.00 0.00							
160 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

ES 10/04/10 (C)

ES 10/04/10 (C)

10/04/21 (J)
MF 10-4-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

April 9, 2010 10:23:52 AM

Page 1

Work Order ID: 57583

Parent Item: D2221

Parent Item Name: 350 Basket Base

Start Date: 4/09/10

Required Date: 4/16/10

Comments: IPP Rev:J 05.09.02 Added D3442-1 UKJ/JLM
 IPP Rev:K 08-08-29 revG as per dwg DD verified by:EC
 IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC
 IPP Rev:M 08-12-02 revH as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

D2221-1 Manufactured No 100 Each 11.0000 1.0000



Rib

Warehouse Loc Qty Loc Code
Location

Main Warehouse

WA

11

57182

11

D2221-5 Manufactured No 100 Each 6.0000 2.0000



Rib

Warehouse Loc Qty Loc Code
Location

Main Warehouse

WA

6

56203

6

D2221-7 Manufactured No 100 Each 3.0000 1.0000



Rib

Warehouse Loc Qty Loc Code
Location

Main Warehouse

WA

3

56202

3

SAD 10-04-09

SAD 10-04-09

SAD 10-04-09

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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April 9, 2010 10:23:53 AM

Page 2

Work Order ID: 57583



Parent Item: D2221



Parent Item Name: 350 Basket Base

Start Date: 4/09/10

Required Date: 4/16/10

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 IPP Rev:K 08-08-29 revG as per dwg DD verified by:EC
 IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC
 IPP Rev:M 08-12-02 revH as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

D2232-3 Manufactured No 100 Each 5.0000 2.0000



Basket Hinge



SAD 10-04-09

Warehouse Loc Qty Loc Code
Location

Main Warehouse

WA

5

54863

5

2

D2235-1 Manufactured No 100 Each 11.0000 2.0000



Basket Rib



SAD 10-04-09

Warehouse Loc Qty Loc Code
Location

Main Warehouse

WA

11

56472

1

57433

10

2

D2581 Manufactured No 100 Each 11.0000 2.0000



Mounting Bracket



SAD 10-04-09

Warehouse Loc Qty Loc Code
Location

Main Warehouse

WA

11

46086

2

51745

2

55918

7

2

April 9, 2010 10:23:53 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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April 9, 2010 10:23:53 AM

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 IPP Rev:K 08-08-29 revG as per dwg DD verified by:EC
 IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC
 IPP Rev:M 08-12-02 revH as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

D3442-1 Manufactured No 100 Each 22.0000 2.0000



Shim



SAD 10-04-09

Warehouse Loc Qty Loc Code
Location

Main Warehouse

WA 22

54071 3

56579 19

2

D3825-041 Manufactured No 100 Each 2.0000 2.0000



Rib Assembly (Basket End)



SAD 10-04-09

Warehouse Loc Qty Loc Code
Location

Main Warehouse

WA 2

56205 2

2

D3826-041 Manufactured No 100 Each 4.0000 2.0000



Rib / Gusset Assembly



SAD 10-04-09

Warehouse Loc Qty Loc Code
Location

Main Warehouse

WA 4

57281 4

2

April 9, 2010 10:23:53 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

April 9, 2010 10:23:53 AM

Page 4

Work Order ID: 57583



Parent Item: D2221

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Start Date: 4/09/10

Required Date: 4/16/10

Comments: IPP Rev:J 05.09.02 Added D3442-1 ☐ KJ/JLM
 IPP Rev:K 08-08-29 revG as per dwg DD verified by:EC
 IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC
 IPP Rev:M 08-12-02 revH as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

D3827-041 Manufactured No 100 Each 4.0000 1.0000
SAD 10-04-09
 Rib Assembly (Inboard)

Warehouse Loc Qty Loc Code
Location

Main Warehouse

WA

4

55982

4

1

D3832-1 Manufactured No 100 Each 1.0000 1.0000
PL 10.04.15
 Mesh (Base)

Warehouse Loc Qty Loc Code
Location

Main Warehouse

WA

1

56179

1

B57280 → 1

D3833-1 Manufactured No 100 Each 5.0000 2.0000
PL 10.04.15
 Mesh (Base End Face)

Warehouse Loc Qty Loc Code
Location

Main Warehouse

WA

5

56396

5

2

April 9, 2010 10:23:53 AM

Shop Packet Print

Page 4

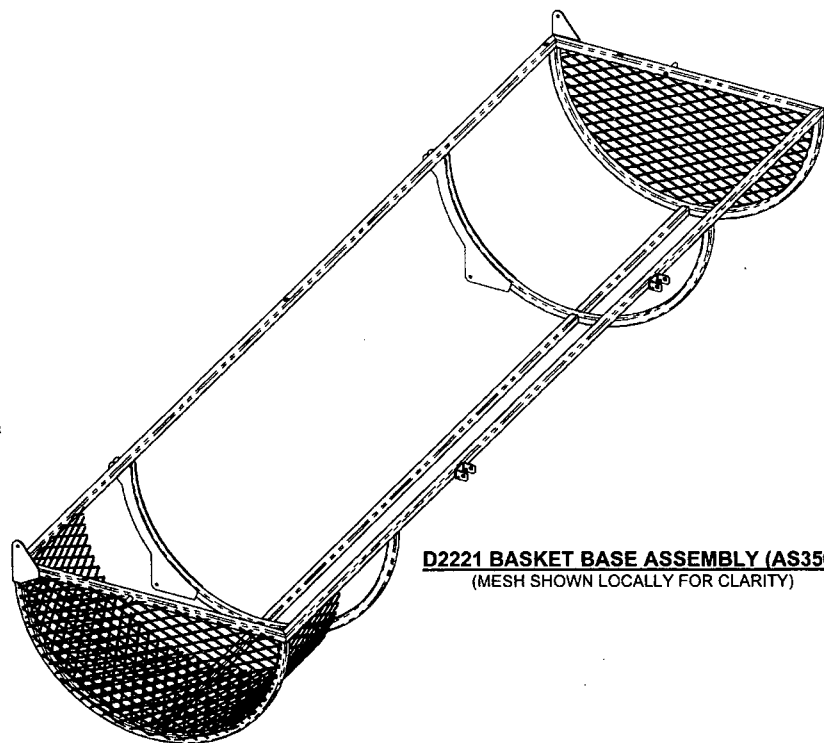
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2221 BASKET BASE ASSEMBLY (AS350)
(MESH SHOWN LOCALLY FOR CLARITY)

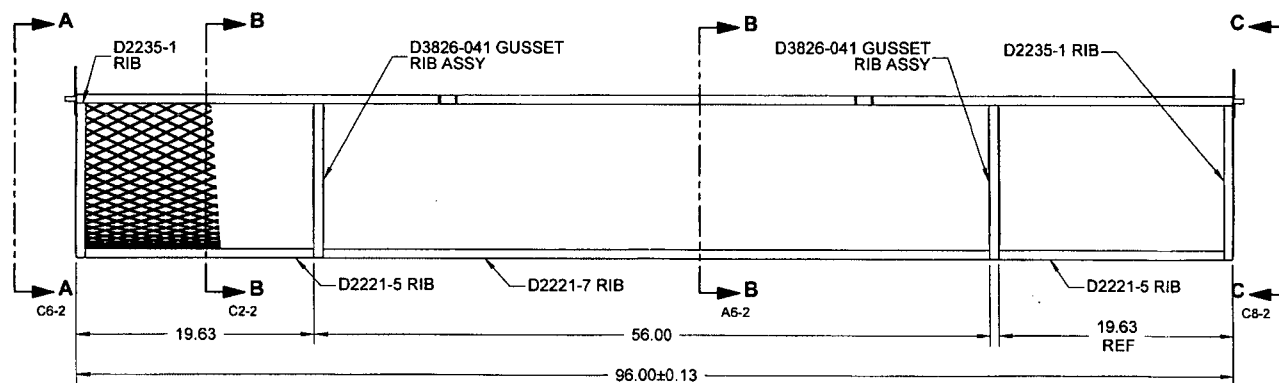
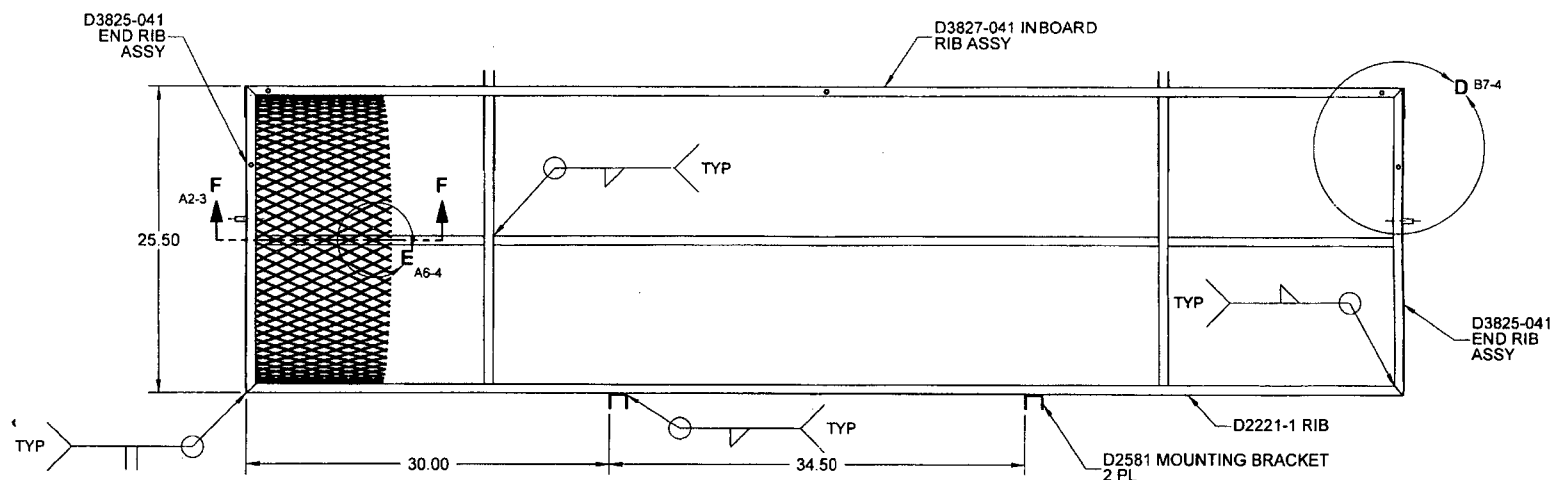
WLO 57583

ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

H	REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN C6-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/-5/-7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/D2327-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.	MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL. TOLERANCE FOR 96.00 DIM WAS +/-0.01 AND 56.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2. SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT	AJS	08.06.16
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARATE BASKET AND LID	KH	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	BW		
CHECKED	BW	DRAWING NO.	REV. H
MFG. APPR.	BW	D2221	SHEET 1 OF 5
APPROVED	BW	TITLE	SCALE
DE APPR.	BW	BASKET BASE ASSEMBLY (350) NTS	
DATE	08.09.18	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

NOTES:

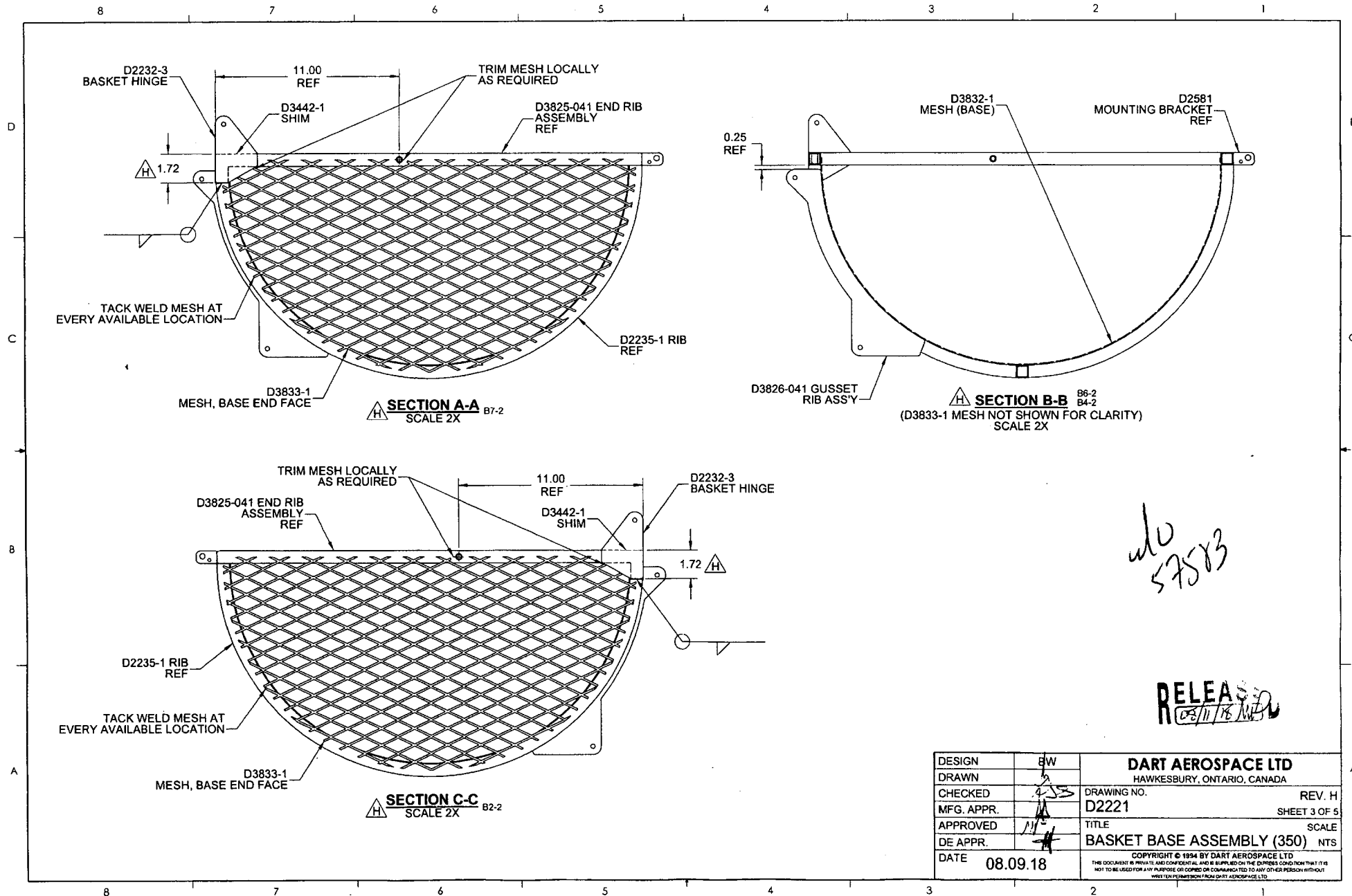
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 42.00 lbs APPROX
- 8) MASK ALL HOLES PRIOR TO POWDER COATING



D2221 BASKET BASE ASSEMBLY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
08/11/18

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



u/s
57583

RELEASE
03/11/18

8 7 6 5 4 3 2 1

D

C

B

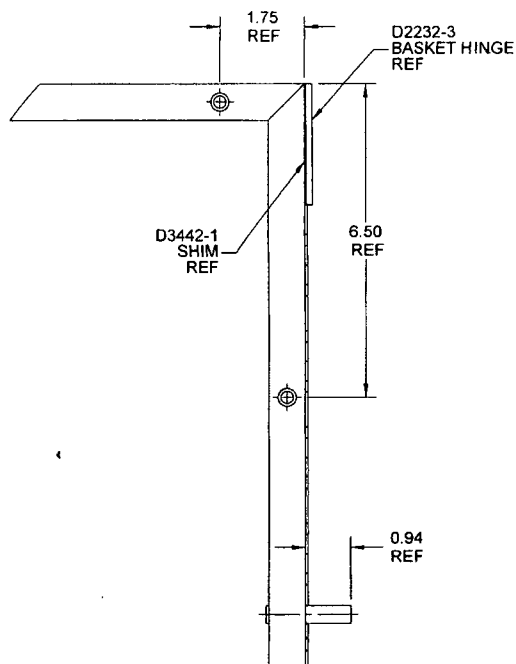
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D

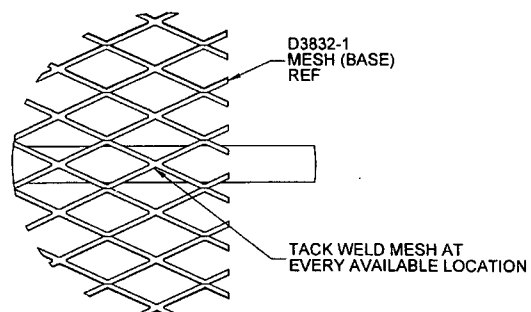
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B

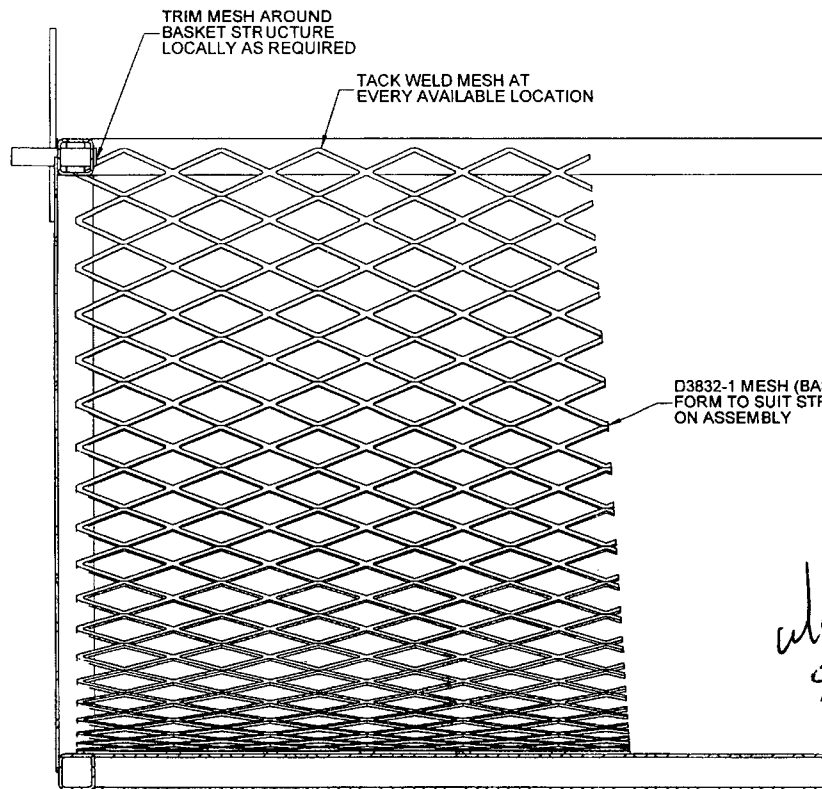
A



DETAIL D
SCALE 4X D2-2



DETAIL E
SCALE 4X C6-2

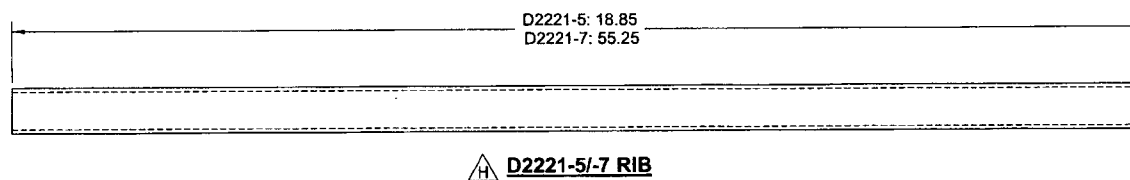
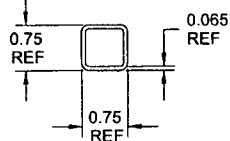
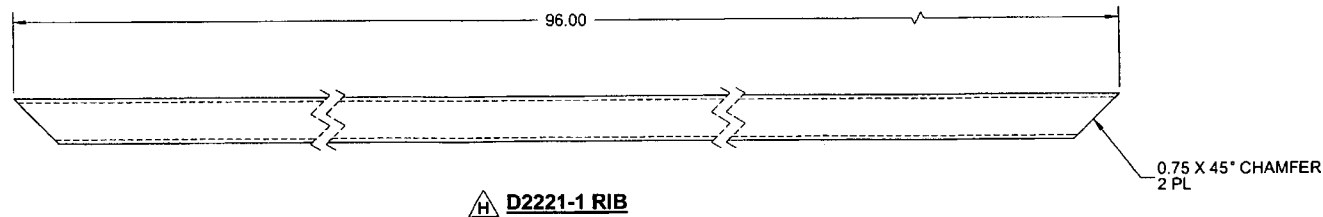
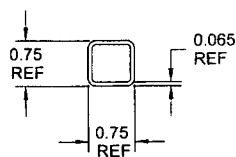


SECTION F-F
SCALE 4X D7-2

RELEASED
02/11/16

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	16/3	DRAWING NO. D2221	REV. H
MFG. APPR.			SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCE TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

8 7 6 5 4 3 2 1






40
57583

RELEASED
08/11/18

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: D2221 -1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350) NTS	
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